

5/30

DART AEROSPACE LTD.	Work Order:	23801
Description: Saddle Fitting, Fwd (Outboard/Inboard)	Part Number:	D2571/D2572
Drawing: D2571 Rev. D/D2572 Rev. D	Qty:	12
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	JL	05.07.14	12
2	MV	Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: <u>B21818</u>	JL	05.07.18	12
3	MV	Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: <u>B23249</u>	JL	05.07.18	12
4	MV	Fixturing W/O No. <u>1</u> Fixturing Inspection last completed <u>1</u> by <u>1</u>	JL	05.07.18	12
5	MV	Program Batch No. <u>23801</u> Double check by: <u>EC</u>	JL	05.07.19	12
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	JL	05.07.25	12
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	JL	05.07.25	12
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	JL	05.07.25	12
9	MV	Machine keyway as per dwg D2571 & D2572	JL	05.07.25	12
10	MV	Deburr and remove all machining marks	JL	05.07.25	12
11	MV	Tumble for 20 minutes to remove sharp edges # <u>04.00.21</u>	JL	05.07.25	12
12	QC1	Inspect all dimensions to dimension sheets	JL	05.07.25	12
13	QC7	Second inspection	EC	05.07.25	12
14	FP	Acid etch and alodine as per QSI 005 4.1	PMC	05.07.27	12
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	FL	05.08.03	12
16	QC3	Inspect Powder Coat	ML	05.08.04	12
17	ST	Identify and Stock.	CL	05.08.04	12
18	AC	Cost / Part <u>155.27</u> <u>118.39</u>	JL	05.08.09	12
19	DC	Close W/O <u>163.00</u> <u>131.15</u> Inspection Level 21	JL	05.08.09	12

Rev	Date	Change	Revised By	Approved
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.02.01	Added Inspection level 5 and Inspection Level 21	SM	
I	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2572	KJ RF	

RELEASED
02/10/15 RF